

A1-625

Work Order ID 73401

Wednesday, August 31, 2011 3:05:23 PM



Item ID: D2594-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug, 205 Skidtube

Start Date: 8/31/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 160.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 11/08/31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2594	Rev C								

100

0.00



Hardinge CNC LATHE SMALL

OK 11/09/20

172 ϕ

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.

110

0.00



QC2- Inspect parts off machine FAI/FAIB

OK 11/09/20

172 ϕ

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

Y.A 11/09/20

172 ϕ

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

172 counted ϕ Jell 11/01/21

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

1:45

3200F

2:15

172x ϕ M-11/01/21

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

172 ϕ Jell 11/01/21

M 118439

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Required Date: 9/9/2011 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location

FP2

0.00



Packaging

Memo

0.00

Packaging

172x Ø m-f 11/04/21

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/22 JF
MK

11-09-22

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 31, 2011 3:05:21 PM

Page 1

Work Order ID: 73401



Parent Item: D2594-1



Parent Item Name: Plug, 205 Skidtube

Start Date: 8/31/2011

Required Date: 9/9/2011

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP D 02.08.22 Make in Cobra KJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased		No		110	f	36.2700	0.0521	8.774737			

6061-T6 Round Bar .625"

Location	Loc Qty	Loc Code
MAT012	36.27	
117284	26.18	
117481	10.09	

9.39

ent 11/09/20

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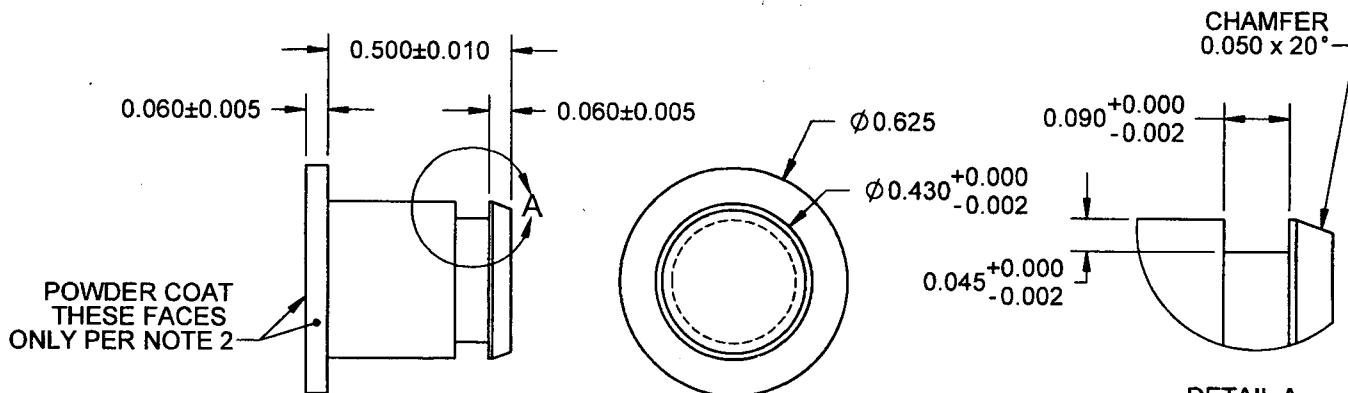
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DESIGN <i>#</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG SCALE 2:1	
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28 *[Signature]*



D2594-1 PLUG

D2594-1 PLUG NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

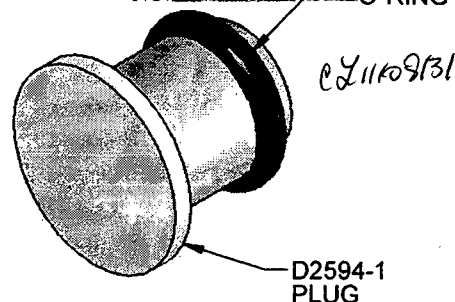
D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *73401* **D2594-3
O-RING**

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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